

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004012**Date Inspected:** 04-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang / Guo Yan Fei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** skin plate assembly, deck plate**Summary of Items Observed:**

Tower shop - Bay 1

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) randomly observed approximately 60 ZPMC workers performing the following: flame cutting of beveled edge on plates; SAW of butt welds between plates; FCAW-G of fill passes of stiffener to SSD1 – skin E assembly in the tilted up position; FCAW-G, manual and automatic, of fill passes of stiffener to SSD1 – skin C assembly; heat straightening of stiffeners; grinding of tacks of stiffener to SSD1 – skin D assembly; removal of restraining jacks on SSD1 – skin B assembly. QA Inspector performed final MT of weld NSD1-SA10A/K-15B. Also present in this bay were ZPMC CWI Li Yang as well as ABF QC's Yang Yi Heng and Jeff Chan, and ZPMC QC Zhang Jiadi. Items observed appeared to comply with project specifications. See conversations below.

Tower shop - Bay 2

QA Inspector randomly observed approximately 50 ZPMC workers performing the following: grinding into cover pass on a tilted up ESD1 – skin A; tacking and grinding of tacks of stiffeners to ESD1 – skin C; FCAW-G of cover pass of stiffeners to ESD1 – skin B; FCAW-G of cover pass of stiffeners to ESD1 – skin E; FCAW-G of fill pass of stiffeners to ESD1 – skin D; SAW of ESD1 skin plate butt welds. Also present in this bay were ZPMC CWI's Guo Yan Fei as ABF QC Luo Lai Quan. Items observed appeared to comply with project specifications.

Heavy Duty Machine Shop – Bay 3

QA Inspector randomly observed 11 ZPMC workers performing the following: SAW of deck plate (no ribs attached) DP545-001 butt weld; grinding of U-rib to deck panels DP557-001 and DP572-001. There were 11 full size panels, 4 half size panels, and 1 panel that had been cut into and samples taken from. Also present in this bay

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

were ABF QC's Wang Zhong Yuan and Ding Bao Hua. QA Inspector asked the two ABF QC's if ZPMC CWI Sun Wei (CWI) had been in the bay. QA Inspector did not observe CWI in the bay on this date. Both ABF QC's said that CWI had been there periodically. Items observed appeared to comply with project specifications.



Summary of Conversations:

QA Inspector informed ABF QC Art Peterson and ABF Engineer Gene Rosamillia of the issue of ZPMC performing a weld repair on 9/3/08 of 4 stiffeners with SMAW using a repair procedure written for FCAW of 2 stiffeners.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, 136-6471-0411, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
